

Work Order ID 75091

October-17-11 1:21:58 PM

75091

Page 1

Item ID: D3574-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cabin Floor Protector
 Start Date: 17/10/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3574	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 B11-10-18
 FLOW CNC Waterjet 1-Cut as per Dwg D3574 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 B11-10-8
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 8/10/19 (V4)
 Quality Control

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.00							
Packaging									

Handwritten signature and date 10/10/20

Handwritten circled mark

Handwritten signature and date 11/10/20

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 17/10/2011 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

11/10/24 JA

MF
11-10-2

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Picklist Print

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Page 1

Work Order ID: 75091

75091

Parent Item: D3574-2

D3574-2

Parent Item Name: Cabin Floor Protector

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	886.1763		134.4672			
MI FXS 125-F60029-04										**		11-10-18	
GE PLASTICS LEXAN SHEET													

Location

Loc Qty

Loc Code

MAT018

886.176289

116236

886.176289

116236

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DART AEROSPACE LTD		Work Order:	75091
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.002	X		V B02	
7.37	+/-0.030	7.37	Ø		T B01	
10.75	+/-0.030	10.75	Ø		T	
11.00	+/-0.030	11.00	Ø		T	
15.25	+/-0.030	15.25	Ø		T	
25.87	+/-0.030	25.87	Ø		T	
39.75	+/-0.030	39.75	Ø		T	
44.75	+/-0.030	44.75	Ø		T	
53.51	+/-0.030	53.51	Ø		T	
63.50	+/-0.030	63.50	Ø		T	
65.25	+/-0.030	65.25	Ø		T	
10.75	+/-0.030	10.75	Ø		T	
11.00	+/-0.030	11.00	Ø		T	
14.75	+/-0.030	14.75	Ø		T	
25.50	+/-0.030	25.50	Ø		T	
25.75	+/-0.030	25.75	X		T	
26.00	+/-0.030	26.00	Ø		T	
32.87	+/-0.030	32.87	Ø		T	
38.81	+/-0.030	38.81	Ø		T	
45.00	+/-0.030	45.00	Ø		T	
48.25	+/-0.030	48.25	Ø		T	
58.38	+/-0.030	58.38	Ø		T	
61.25	+/-0.030	61.25	Ø		T	
64.13	+/-0.030	64.13	Ø		T	
64.63	+/-0.030	64.63	Ø		T	
66.50	+/-0.030	66.50	Ø		T	
7.50	+/-0.030	7.50	Ø		T	
9.50	+/-0.030	9.50	Ø		T	
10.38	+/-0.030	10.38	Ø		T	
10.88	+/-0.030	10.88	Ø		T	
14.50	+/-0.030	14.50	Ø		T	
16.56	+/-0.030	16.56	Ø		T	
18.75	+/-0.030	18.75	Ø		T	
24.13	+/-0.030	24.13	Ø		T	

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DART AEROSPACE LTD		Work Order:	75091
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.00	✓		T IB01	
30.50	+/-0.030	30.75	✓		T	
33.88	+/-0.030	33.88	✓		T	
39.50	+/-0.030	39.50	✓		T	
40.25	+/-0.030	40.75	✓		T	
43.50	+/-0.030	43.50	✓		T	
46.60	+/-0.030	46.60	✓		T	
7.63	+/-0.030	7.63	✓		T	
11.00	+/-0.030	11.00	✓		T	
11.50	+/-0.030	11.50	✓		T	
16.75	+/-0.030	16.75	✓		T	
19.00	+/-0.030	19.00	✓		T	
22.50	+/-0.030	22.50	✓		T	
30.75	+/-0.030	30.75	✓		T	
32.63	+/-0.030	32.63	✓		T	
32.75	+/-0.030	32.75	✓		T	
35.13	+/-0.030	35.13	✓		T	
36.50	+/-0.030	36.50	✓		T	
40.00	+/-0.030	40.00	✓		T	
41.88	+/-0.030	41.88	✓		T	
43.63	+/-0.030	43.63	✓		T	
0.125	+/-0.010	0.130	✓		V IB02	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-10-18	Date: 11/10/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

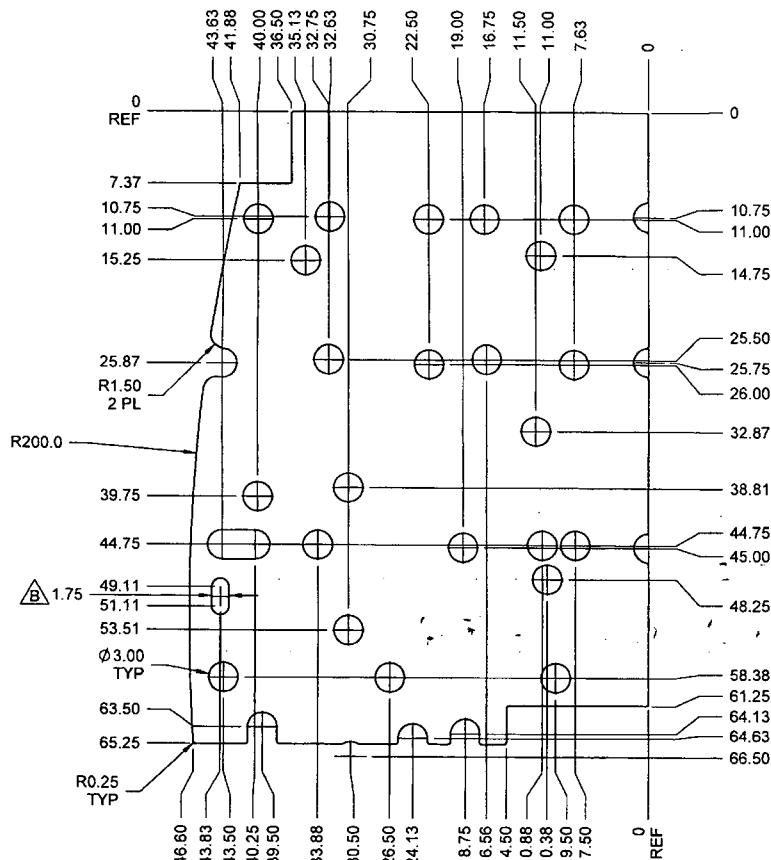
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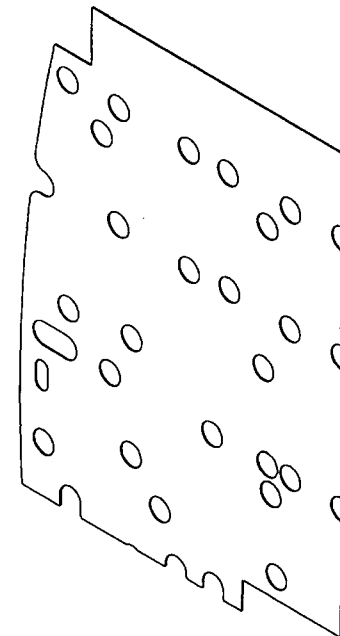
NOTE: Date & initial all entries



D3574-1 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP, (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3574-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 7) WEIGHT: 14.30 lbs
- 8) CHECK PER TEMPLATE DT8961



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75091 M.L.J.

11/10/17 **RELEASED**
01/07/17

B	ADD CUT-OUT TO -1/4" FOR WEIGHT AND BALANCE DATA PLATE ZN B7-1, B8-5; -2 NOW SHOWN ON SHEET 2	09.03.25
A	NEW ISSUE	CB 07.05.08
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.03.25	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3574** REV. B
SHEET 1 OF 6
TITLE **CABIN FLOOR PROTECTOR** SCALE NTS

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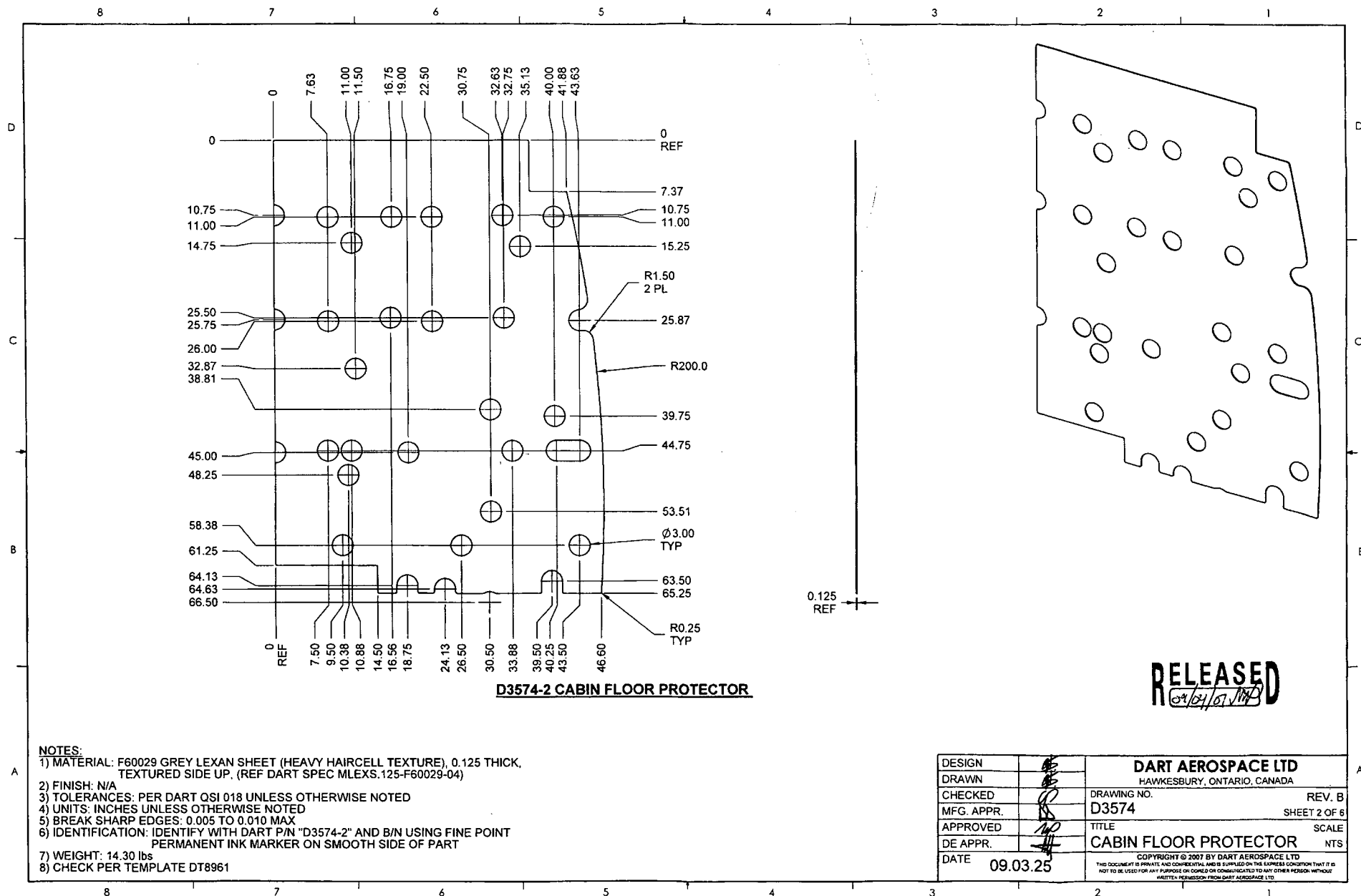
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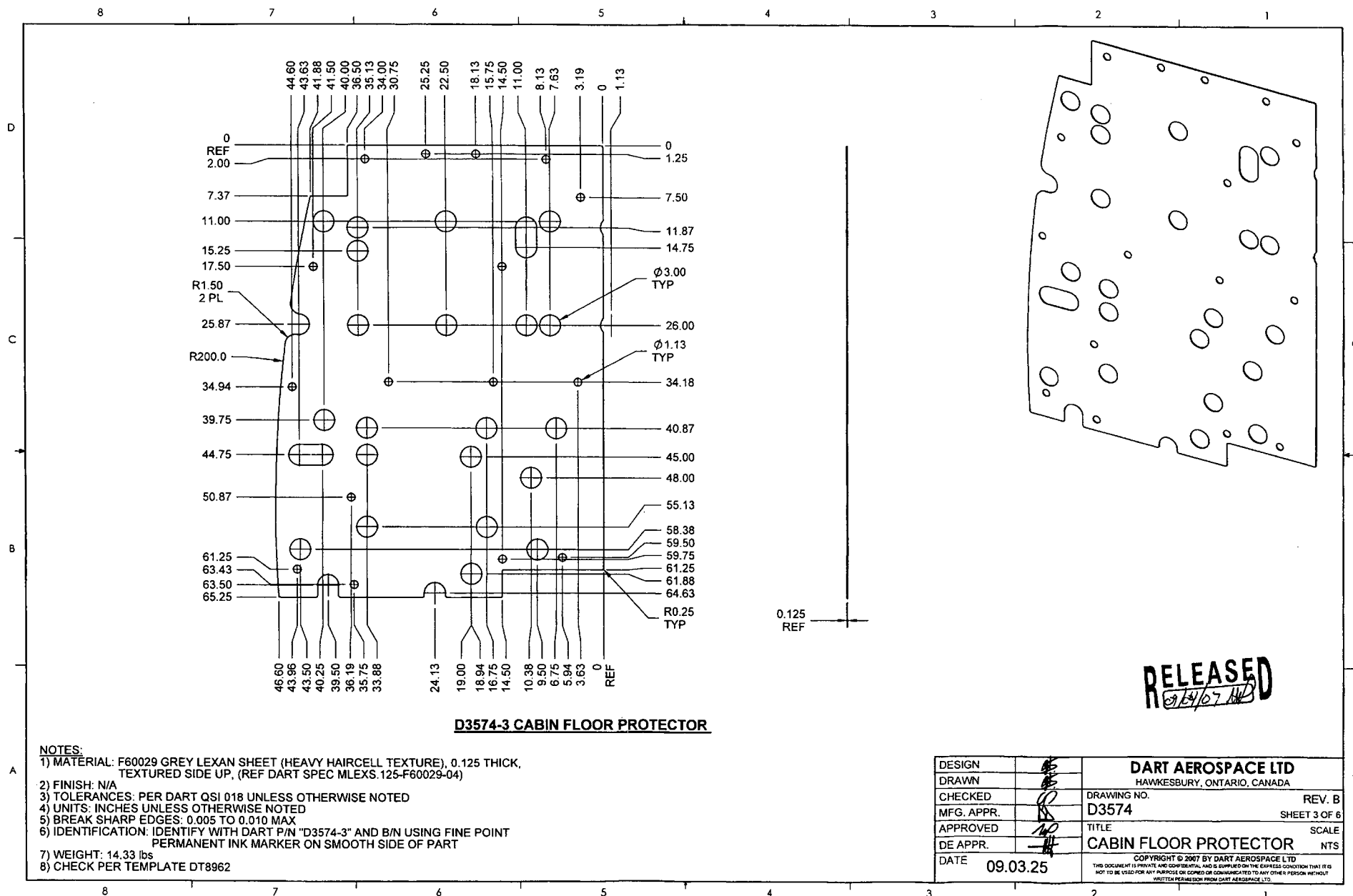
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8 7 6 5 4 3 2



RELEASED
09/07/07 JVP

7) WEIGHT: 14.18 lbs
8) CHECK PER TEMPLATE DT8963

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3574 TITLE CABIN FLOOR PROTECTOR COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED BY THE USER. NO PARTS OR CONTENTS MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD. THIS DOCUMENT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. B
DRAWN	<i>[Signature]</i>		SHEET 4 OF 6
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.03.25		

Dart Aerospace Ltd

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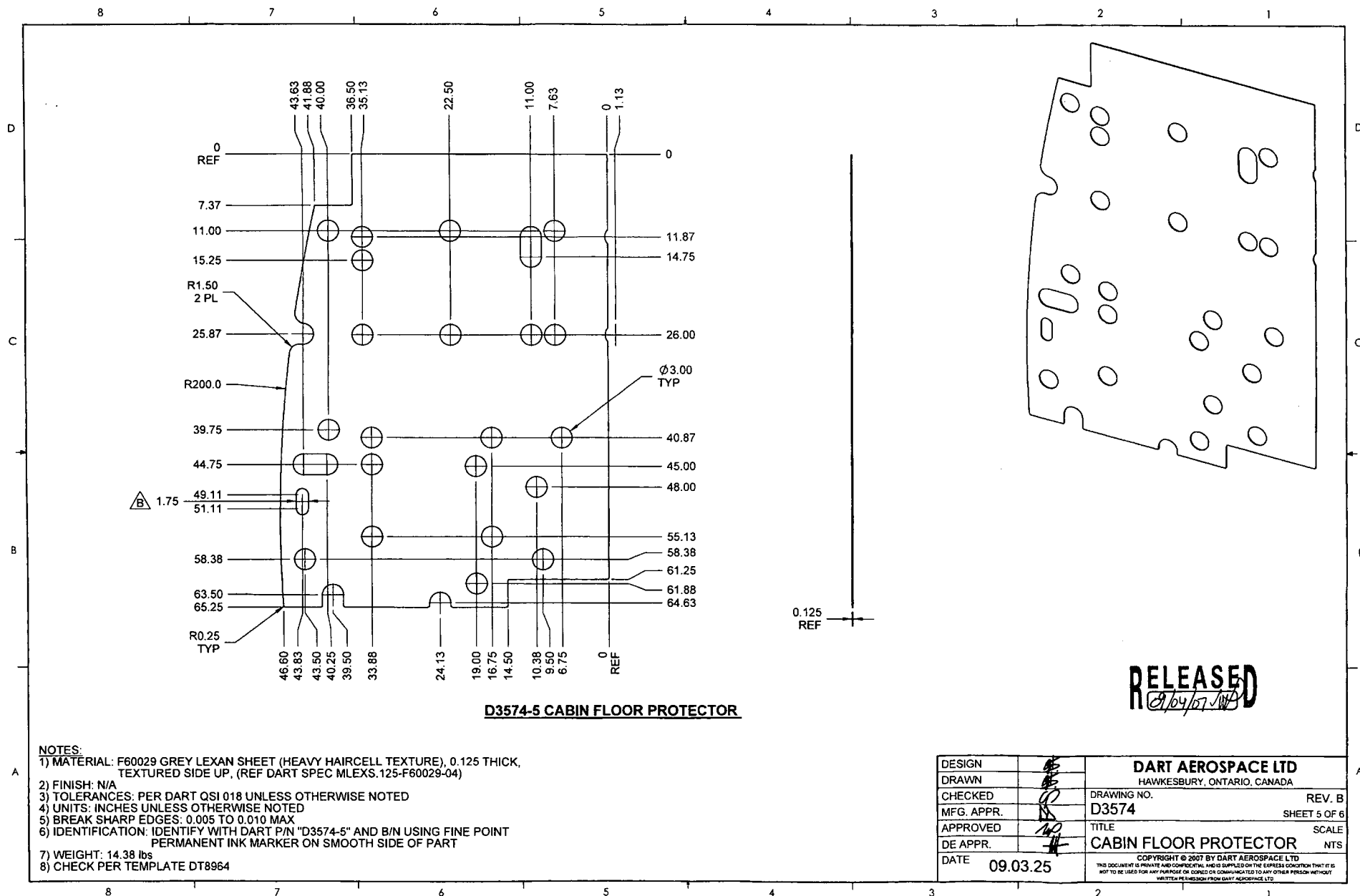
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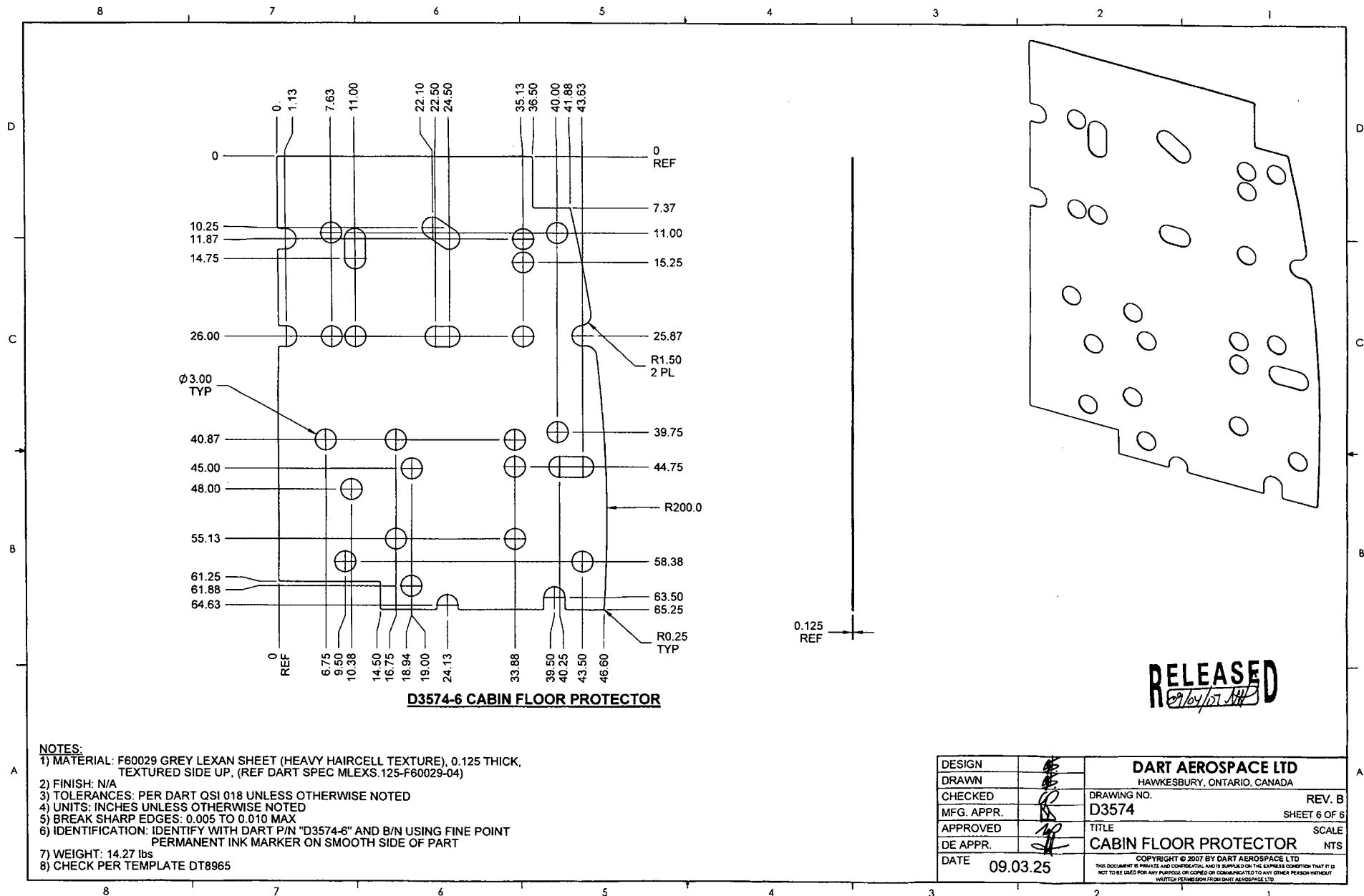
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